



AUTOMOTIVE REFINISH

GLOBAL
REFINISH
SYSTEM



Product Information

Corrosion Resistant Primer

D822

Product Description

D822 Corrosion Resistant Primer is a two-pack primer for use under Global topcoat colours. It can be used either as a primer-surfacer or as a non-sanding primer sealer. It must be activated with D823 Corrosion Resistant Primer Catalyst.

Preparation of Substrate



In all cases, wash with soap and water, then use the appropriate Global cleaner. See GLG142 Global Cleaners bulletin for selection and usage instructions. Ensure that the substrate is thoroughly cleaned and dried both before and after preparation work.

Original Paintwork and Electrodeposition Primer must be sanded using European P280 / U.S. 240 grit discs (dry) or European P360 / U.S. 320 grade paper (wet). Exposed bare metal should be spot-primed with a suitable bare metal primer (see below).



Bare Steel and Aluminum must be clean, rust-free and abraded before application (minimum 2 coats of D822). For maximum corrosion resistance apply one coat of D831 Chromate-free Wash Primer.



Galvanized Steel must be thoroughly abraded and primed with one coat of D831 Chromate-free Wash Primer.

Polyester Body Fillers should be dry sanded using European P400 / U.S. 360 grit paper.

Fibre Glass and SMC should be dry sanded using European P280 / U.S. 240 grit paper. A minimum of 2 coats of D822 is required over these substrate types.

Ensure that the substrate is thoroughly cleaned and dried after preparation work.

APPLICATION GUIDE

Mixing Ratio

Primer-Surfacer



***D822 3 vols**
D823 1 vol

*If VOC is not a concern, add up to ½ vol of the appropriate temperature range Global thinner to improve flow properties and potlife.

Primer-Sealer



D822 3 vols
D823 1 vol
D-Thinner ½ vol

D-Thinner Selection:

D870

D871

D872

D873

Appropriate Temperature Range:

Up to 18°C / 65 °F

18° - 25°C / 65° - 77°F

25° - 35°C / 77° - 95°F

Over 35°C / 95°F

Note: D8700 Retarder may be mixed with thinners in temperatures over 35°C / 95°F. The retarder can be mixed up to 25% with the appropriate thinner. Do not use alone as a reducer.

Potlife



@ 20°C / 68°F

1 - 1½ hours

Additives



D822 can be tinted using DG toners only! When mixed it can be sprayed as a surfacer or sealer.

3 vols - D822
1 vol - D823
1 vol - D-Thinner
1 vol - DG Toner

Spraygun set-up



Fluid Tip

Spray Viscosity

1.4 – 1.6 mm or equivalent

22 seconds ZAHN #2 @ 20°C / 68°F

Spray pressure

HVLP at air cap

Conventional at spray gun

0.7 bar / 10 PSI

3 - 4 bar / 45 - 55 PSI

Number of coats



Primer Surfacer

Primer Sealer

2 – 4 wet coats

1 – 2 wet coats

Primer Surfacer

Sealer or Tinted Sealer

Recommended film build per wet coat

Recommended dried film build per coat

3.5 – 4.0 mils

2.0 mils

3.0 – 3.5 mils

1.5 mils

Flash off at 20°C / 68°F



Between coats

Before stoving

5 – 10 minutes

10 minutes

Before Topcoat

20 minutes minimum (1 coat)

45 minutes minimum (2 coats)

8 hours maximum, before sanding is required

APPLICATION GUIDE

Drying times



Dust-free
20°C / 68°F: 10 minutes



Dry to sand
20°C / 68°F: 1 – 2 hours
60°C / 140°F: 20 – 30 minutes
If rework is necessary,



Tape Time
20°C / 68°F: 1 – 2 hours
60°C / 140°F: 20 – 30 minutes



IR (Infrared)
Medium wave: 20 minutes
Short wave: 10 minutes (includes 3 minute ramp-up time)

Overcoat /Recoat



Topcoat over Primer Sealer
20 minutes minimum (1 coat)
45 minutes minimum (2 coats)
8 hours maximum, before sanding is required



Overcoat with Any Global topcoat

Sanding



If rework is necessary or maximum flashtime is exceeded,
Grade wet European P600 / U.S. 400
followed by European P1200 / U.S. 600
Grade dry European P360 / U.S. 320
followed by European P1000 / U.S. 500

Performance Guidelines

The use of HVLP spray equipment can give an increase in transfer efficiency of about 10% depending on the make and model of equipment used.

If D822 is used for spot priming, the panel to be primed must be thoroughly sanded beyond the edge of the spot repair.

Technical Data

Total Dry Film Build:	Primer Surfacer	Sealer or Tinted Sealer
<i>Minimum after sanding</i>	50 µm / 2.0 mils	37 µm / 1.5 mils
<i>Maximum after sanding</i>	150 µm / 6.0 mils	75 µm / 3.0 mils
<i>Film Build Per wet coat</i>	87 - 100 µm / 3.5 – 4.0 mils	75 - 87 µm / 3.0 - 3.5 mils
<i>Dried film build per coat</i>	50 µm / 2.0 mils	37 µm / 1.5 mils
**Theoretical Coverage:	5.3 m ² per l / 217 sq.ft. per US gal.	12.5 m ² per l / 514 sq.ft. per US gal.
<i>When Tinted 3:1:1:1</i>	4.3 m ² per l / 174 sq.ft. per US gal.	11.3 m ² per l / 464 sq.ft. per US gal.
% Solids By Volume RTS	54.2	48.1
<i>When Tinted 3:1:1:1</i>	43.4	43.4

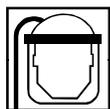
**Theoretical coverage in m²/litre and sq.ft./US gal. ready-to-spray (RTS), giving 100µm (4 mils) dry film thickness for Primer Surfacer and 37µm (1.5 mils) for primer sealer.

VOC

(D822)	395 gms per litre / 3.3 lbs per US gal.
(D822:D823, 3:1)	360 gms per litre / 3.0 lbs per US gal. (less exempts)
(D822:D823:D872, 3:1:½)	419 gms per litre / 3.5 lbs per US gal. (less exempts)
(D822:D823:DG:D872, 3:1:1:1)	467 gms per litre / 3.9 lbs per US gal. (less exempts)

Health and Safety

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



- The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and MSDS's of all the components, since the mixture will have the hazards of all its parts.
- Improper handling and use, for example, poor spray technique, inadequate engineering controls and/or lack of proper Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company policy, product MSDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on MSDS.
- Always observe all applicable precautions and follow good safety and hygiene practices.

Emergency Medical or Spill Control Information (304) 843-1300; In Canada (514) 645-1320

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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Global At A GLANCE

D822

Corrosion Resistant Primer

Mix:  Primer-Surfacer	*D822 3 vols D823 1 vol	<table border="1"> <thead> <tr> <th><u>D-Thinner</u></th> <th><u>Temperature Range</u></th> </tr> </thead> <tbody> <tr> <td>D870</td> <td>Up to 18°C / 65 °F</td> </tr> <tr> <td>D871</td> <td>18° - 25°C / 65° - 77°F</td> </tr> <tr> <td>D872</td> <td>25° - 35°C / 77° - 95°F</td> </tr> <tr> <td>D873</td> <td>Over 35°C / 95°F</td> </tr> </tbody> </table>	<u>D-Thinner</u>	<u>Temperature Range</u>	D870	Up to 18°C / 65 °F	D871	18° - 25°C / 65° - 77°F	D872	25° - 35°C / 77° - 95°F	D873	Over 35°C / 95°F
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 Primer-Sealer	*D822 3 vols D823 1 vol D-Thinner ½ vol											
Additives: 	D822 can be tinted using DG toners <u>only!</u> When mixed it can be sprayed as a surfacer or sealer.	3 vols of D822 1 vol of D823 1 vol of appropriate D-Thinner 1 vol of DG Toner										
Pot life: 	@ 20°C / 68°F	1 - 1½ hours										
Air Pressure: 	HVLP at the cap: Conventional at the gun: Fluid tip:	0.7 bar / 10 PSI 3 - 4 bar / 45 - 55 PSI 1.4 - 1.6 mm or equivalent										
Application: 	Apply as Primer Surfacer Apply as Primer Sealer: Between coats:	2 – 4 wet coats 1 – 2 wet coats 5 – 10 minutes <table border="0" style="width: 100%;"> <tr> <td style="text-align: center;"><u>Primer Surfacer</u></td> <td style="text-align: center;"><u>Sealer or Tinted Sealer</u></td> </tr> <tr> <td style="text-align: center;">Film Build Per wet coat:</td> <td style="text-align: center;">3.5 – 4.0 mils</td> </tr> <tr> <td style="text-align: center;">Dried Film Build Per coat:</td> <td style="text-align: center;">2.0 mils</td> </tr> <tr> <td></td> <td style="text-align: center;">3.0 – 3.5 mils</td> </tr> <tr> <td></td> <td style="text-align: center;">1.5 mils</td> </tr> </table>	<u>Primer Surfacer</u>	<u>Sealer or Tinted Sealer</u>	Film Build Per wet coat:	3.5 – 4.0 mils	Dried Film Build Per coat:	2.0 mils		3.0 – 3.5 mils		1.5 mils
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Dry Times: 	Before stoving:	10 minutes										
	Dust-free 20°C / 68°F: 60°C / 140°F	10 minutes If rework is necessary, 1 – 2 hours 20 – 30 minutes**										
	Tape Time 20°C / 68°F: 60°C / 140°F	1 – 2 hours 20 – 30 minutes**										
	IR (Infrared) Medium wave Short wave	20 minutes 10 minutes (includes 3 minute ramp time)										
	Overcoat Primer Sealer 20°C / 68°F:	20 minutes minimum (1 coat) 45 minutes minimum (2 coats) 8 hours maximum before sanding is required										

**Stoving times are for quoted metal temperature. Additional time should be allowed in the force-drying schedule to allow metal to reach recommended temperature.

Warning: Do not use sealer applications over polyester body filler substrates.

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